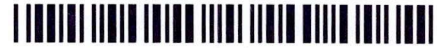




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3205-00E
Job Sheet 193169



Part No: RBE350A93-3205-00E

Job Qty: 12 pcs

Part Name: Engine Gear Box Input Flange Holding Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3205-00E Rev 2A IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	12 pcs	5/6/19	5/6/19	0.00	1.20	Waterjet - Omax	2/19/06/03
110	QC 2	12 pcs	5/6/19	5/6/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	2/19/06/03
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S184802



Part: RBE350A93 - 3205 - 00E

Job No: 193169

Serial No/Batch: S184802

Revision: 2A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/24/19

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				QC 2 - 5	
				QC 2 - 71	
120 NV5000 - 1 - B4B	12 pcs	5/6/19	0.00 12.00	NV5000 - 1 - B4B	J.C.L.
				NV5000 - 2 - B4B	
130 QC 2	12 pcs	5/6/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	J.C.L. 16-06-11
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
140 QC 8	12 pcs	5/6/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	J.C.L. 19/06/14
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	

				QC 8 - 23		
170	Outsource - 4 - Anodize	12 pcs	5/6/19		ATG001-VC	GR00030 2019-06-17
180	Packaging 2-1 - Receive - B4B	12 pcs	5/6/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190	QC 6	12 pcs	5/6/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	JUN 2 4 2019 40
					QC 6 - 61	9-89
191	Small Fab - 2 - B4B	12 pcs	5/6/19	0.00 2.40	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
192	QC 5	12 pcs	5/6/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	DAS
						QC 5 - 40	JUN 26 2019 40
							9-89
206 Packaging 3-1 - Stock - B4B	12 pcs	5/6/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
210 QC 21 - FG	12 pcs	5/6/19	0.00	0.00		QC 21 - FG - 21	
						QC 21 - FG - 70	JUN 27 2019 DAS 70
						QC 21 - SA - 53	9-89

Part Op 100 - OMAX (Waterjet 2) 1-Cut as per Dwg Dwg Rev: 2A Prog Rev: 2A 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) 1-Machine as per folio FB743 FOLIO REV: AA DWG
 REV: 2A 2-Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 170 - -Issue P/O to ATG : PO 43752 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water
 sealant As Per Dwg RBE350A93-3205-00E Rev. 2A
 180 - (Receive & Inspect for Damage & Mat'l Certs)
 190 - (QC6- All purchased or subcontracted products)
 191 - (Small Fab) Pick, bag and tag. ***See engineering for hardware sign off. WAS AN315-5, IS AN315-5R***
 192 - (QC5- Inspect part completeness to step on W/O)
 206 - (Identify as per dwg & Stock Location: _____) Bag and tag
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	4.8000 sf (.4 ea)	100-Waterjet - Omax - 1	515967
AN315-5R	Nut 5/16-24	36 Ea (3 ea)	191-Small Fab - 2 - B4B	5166946
AN5-7	Hex Head Cap Screw	36 Ea (3 ea)	191-Small Fab - 2 - B4B	5089124
NAS1149F0563P	Washer	36 Ea (3 ea)	191-Small Fab - 2 - B4B	5098031

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M6061T6S.250	5	86	0
191-Small Fab - 2 - B4B	AN315-5R	36	347	0
	AN5-7	36	151	0
	NAS1149F0563P	36	393	0

Part Specifications

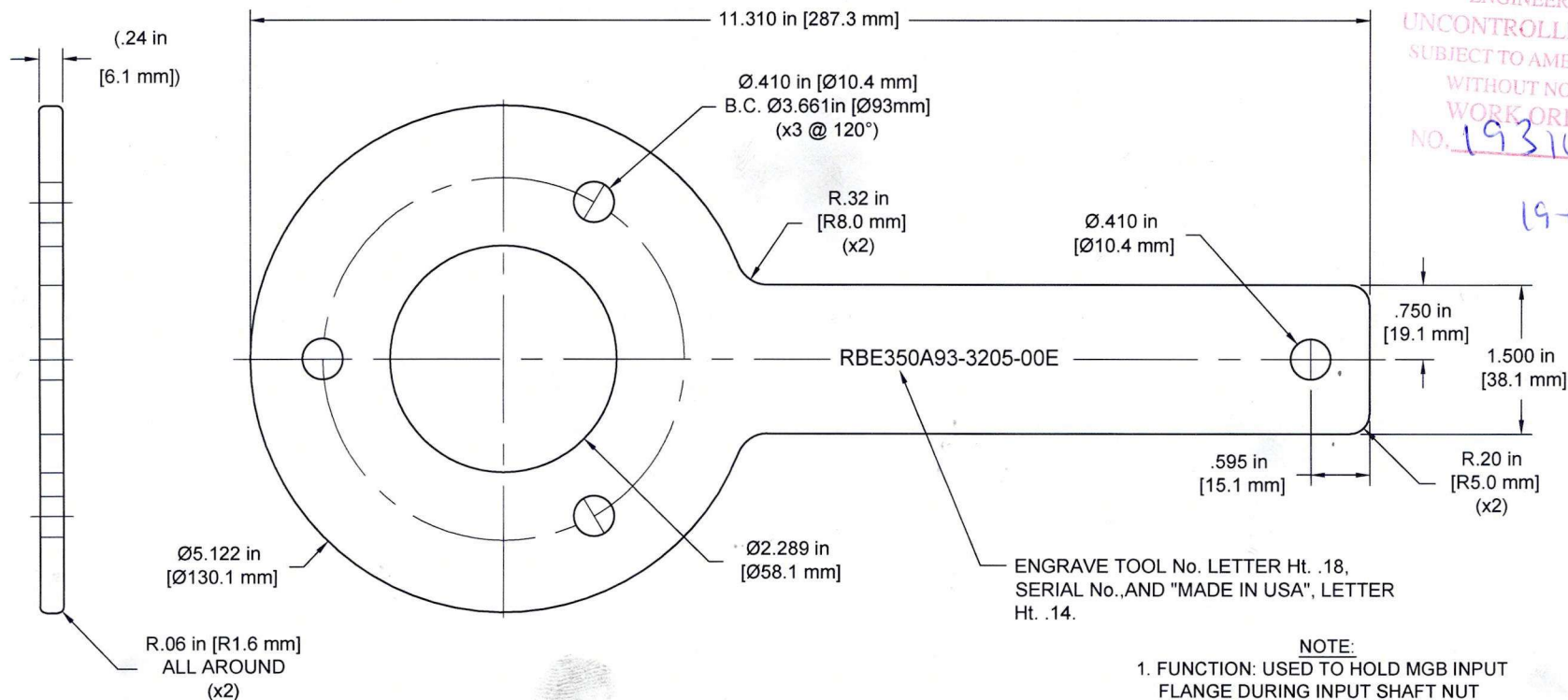
Specifications could not be found.

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	PER HELI PRODUCTS TOOLS.	10/22/09	WP	DW
2	CH'D HOLE DIAMETER FROM .402 TO .410, ADDED MISSING R.063 DIM. PER G.E.	9/15/11	RJC	RW
2A	CORRECTED T/N WAS RBEA93-3205-00E IS RBE350A93-3205-00E. CH'D DIMENSION PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS.	11/5/13	RJC	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193169
19-04-09



NOTE:
1. FUNCTION: USED TO HOLD MGB INPUT FLANGE DURING INPUT SHAFT NUT REMOVAL OPERATION.

RED BARN MACHINE	
TITLE ENGINE GEAR BOX INPUT FLANGE HOLDING WRENCH	
DWG NO. RBE350A93-3205-00E	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-22-08
SHEET 1 of 1	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
				1	ENGINE WRENCH	6061	1/4 x 5-1/4 x 11-1/2
		B/O		3	HEX HEAD CAP SCREW	STEEL	5/16-24 UNF x 31/32 AIRCRAFT SPRUCE #AN5-7
		B/O		3	NUT	STEEL	5/16-24 UNF AIRCRAFT SPRUCE #AN315-5
		B/O		3	FLAT WASHER	STEEL	Ø5/16 I.D. AIRCRAFT SPRUCE #AN960-516
ASSY #							

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S184802



Part: RBE350A93-3205-00E

Job No: 193169

Serial No/Batch: S184802

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 05/28/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043752



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043752
PO Date: 6/17/19
Due Date: 6/24/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-06-18

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193763	C2-1-1	Manual Release Knob (Outsource process- Anodize per QSI017 4.1.10.1)-Issue PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	6/24/19	10 pcs	0 pcs	10 pcs	\$2.8571/pcs	\$28.57
						10 X JUN 24 2019					
2	194906	RB910-0020-1	Quill -Issue PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2	Firmed	-	6/24/19	16 pcs	0 pcs	16 pcs	\$2.8571/pcs	\$45.71
						16 X JUN 24 2019					
3	193169	RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench -Issue PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A	Firmed	-	6/24/19	16 pcs	0 pcs	16 pcs	\$2.8571/pcs	\$45.71
						16 X JUN 24 2019					

DAS
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Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER

POHB043752



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193171	RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed	-	6/24/19	16 pcs	0 pcs	16 pcs	\$4.50/pcs	\$72.00
5	193358	RBE350A93-3302-02-1	Handle (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	-	6/24/19	12 pcs	0 pcs	12 pcs	\$5.49/pcs	\$65.88
6	195093	RBE350A93-3712-00-22	Stop -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	6/24/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
Grand Total:											\$377.88



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB043752



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/18/19 9:23 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020078-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020078- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Jun-2019		SVETLANA DORZHIYEVA		POHB043752				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C2-1-1 Rev.	C2-1-1 01 -ANO-RED [ANODIZE RED] AS PER IAW MIL-A-8625 TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
2	RB910-0020-1 Rev.	RB910-0020-1 01 -ANO-RED [ANODIZE RED] AS PER IAW MIL-A-8625 TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	16	16	0	0	0
3	RBE350A93-3205-00E Rev.	RBE350A93-3205-00E ANODIZE RED AS PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	16	16	0	0	0
4	RBE350A93-3205-00T Rev.	RBE350A93-3205-00T ANODIZE BLACK AS PER MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	16	16	0	0	0
5	RBE350A93-3302-02-1 Rev.	RBE350A93-3302-02-1 ANODIZE BLACK AS PER MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	12	12	0	0	0
6	RBE350A93-3712-00-22 Rev.	RBE350A93-3712-00-22 01 -ANO-CLEAR [ANODIZE CLEAR] AS PER IAW MIL-A-8625 TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0

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JUN 21 2019
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RECEIVED

JUN 21 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.